

Work Order ID 61232

August 11, 2010 11:09:16 AM



Page 1

Item ID:	D2938-2UP	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	206 Saddle Right side-unpainted					
Start Date:	8/11/10	Start Qty:	6.00		Cust Item ID:	
Required Date:	8/25/10	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CZ</u>	Date:	<u>10/8/11</u>	Tooling:		Date:	
	QC:		Date:		SPC (Y/N):		Date:	

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2938	Rev C								

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

DT 10/08/13

6 0

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Conventional Milling Machine

Memo

0.00

Machine Keyway and inspect per attached dimension sheet

DT 10/08/13

6 0

120

0.00



QC1- Inspect dimensions to dimension sheet

QC

Quality Control

Memo

0.00

DT 10/08/13

6 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID:	D2938-2UP	Accept		Setup	Start	
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Required Date:	8/25/10	Req'd Qty:	6.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	J.A 10/08/28			6	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	ml 10 08 31 (6)						
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	(E) 10-8-81						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61232

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Item ID: D2938-2UP

Accept



Setup Start



Revision ID:

Stop



Item Name: 206 Saddle Right side-unpainted

Start Date: 8/11/10 Start Qty: 6.00



Cust Item ID:

Required Date: 8/25/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Packaging

Identify as per dwg & Stock Location: 431

0.00

Memo

0.00

Packaging

C/L 8/31 (6)

170



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

10/08/31 [Signature]
C/L 10/8/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 61232

Parent Item: D2938-2UP

Parent Item Name: 206 Saddle Right side-unpainted




Start Date: 8/11/10

Required Date: 8/25/10

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003  Saddle Billet, 7075		Manufactured	No			100	Each	22.0000	1	6			

Location

MAT042
✓ 59196

Loc Qty

22
22

Loc Code

6 DJP 10/08/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 61232
Description: 206 Saddle, Outboard, Right side	Part Number: D2938-2
Inspection Dwg: D2938 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.115	0.115	0.117	0.116	118-120	Deep mic
B	0.100	0.140		0.115	0.115	0.114	0.114		"
C	0.100	0.140		0.125	0.125	0.123	0.120		"
D	0.210	0.230		0.220	0.218	0.219	0.219	DJP-2	mic
E	1.245	1.255		1.250	1.250	1.250	1.250	DJP-11	Vern
F	1.245	1.255		1.250	1.250	1.250	1.250		"
G	2.495	2.505		2.500	2.500	2.500	2.500		"
H	0.510	0.515		0.511	0.511	0.511	0.511		"
I	1.572	1.582		1.577	1.577	1.577	1.577		"
J	2.495	2.505		2.500	2.500	2.500	2.500		"
K	0.257	0.262		0.259	0.259	0.259	0.259		"
L	0.312	0.317		0.316	0.316	0.316	0.316		"
M	0.235	0.240		0.238	0.238	0.238	0.238	DJP-2	mic
N	0.100	0.140		0.120	0.120	0.120	0.120		"
O	0.540	0.560		0.540	0.547	0.547	0.548	DJP-11	Vern
P	0.490	0.510		0.500	0.504	0.501	0.501		"
Q	3.715	3.725		3.720	3.720	3.720	3.720		"
R	2.720	2.760		2.740	2.740	2.740	2.740		"
S	0.240	0.270		0.245	0.243	0.243	0.243		"
T	0.100	0.180		0.145	0.145	0.145	0.145		"
U	1.625	1.635		1.630	1.630	1.630	1.630		"
V	1.362	1.372		1.367	1.367	1.367	1.367		"
W	0.316	0.321		0.318	0.318	0.318	0.318		"
X	1.250	1.270		1.261	1.263	1.263	1.262		Dial
Y	1.565	1.585		1.5765	1.578	1.577	1.576		"
Z	0.178	0.198		0.188	0.188	0.188	0.188		Rad gage
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: DJP
Date: 10/08/23

Audited by: H.A
Date: 10/08/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 61232
Description: 206 Saddle, Outboard, Right side	Part Number: D2938-2
Inspection Dwg: D2938 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	3	4		
A	0.100	0.140		0.120	0.115			18-120	Deep Mic
B	0.100	0.140		0.120	0.115				"
C	0.100	0.140		0.125	0.122				"
D	0.210	0.230		0.220	0.219			DTP-02	M.C
E	1.245	1.255		1.250	1.250			DTP-11	Ver'n
F	1.245	1.255		1.250	1.250				"
G	2.495	2.505		2.500	2.500				"
H	0.510	0.515		0.511	0.511				"
I	1.572	1.582		1.577	1.577				"
J	2.495	2.505		2.500	2.500				"
K	0.257	0.262		0.259	0.259				"
L	0.312	0.317		0.316	0.316				"
M	0.235	0.240		0.238	0.238			DTP-02	Mic
N	0.100	0.140		0.121	0.120				"
O	0.540	0.560		0.549	0.547			DTP-11	Ver'n
P	0.490	0.510		0.502	0.505				"
Q	3.715	3.725		3.720	3.720				"
R	2.720	2.760		2.740	2.740				"
S	0.240	0.270		0.246	0.245				"
T	0.100	0.180		0.145	0.145				"
U	1.625	1.635		1.630	1.630				"
V	1.362	1.372		1.367	1.367				"
W	0.316	0.321		0.318	0.318				"
X	1.250	1.270		1.263	1.261				Dial
Y	1.565	1.585		1.577	1.575				"
Z	0.178	0.198		0.188	0.188				Rad Gage
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:
Date: 10/08/23

Audited by: J. A.
Date: 10/08/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

